

Work Order ID 79736

79736

Page 1

February-01-12 8:50:39 AM

Item ID: D3150-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Guide

Start Date: 01/02/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 15/02/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/02/01

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3150

Rev C

(9)

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT AS PER DWG

DWG REV: E

PROG REV: E

304 1125

DEBURR

12-5-24

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12-5-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79736

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Item ID:	D3150-1	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:						
Item Name:	Guide				Stop	*NS2*
Start Date:	01/02/2012	Start Qty: 4.00	*4*	Cust Item ID:		
Required Date:	15/02/2012	Req'd Qty: 4.00	*4*	Customer:		
Reference:						

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	*NR1*
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____			

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC8- Inspect parts - second check

0.00

5/21/29

0.00

120

QC

Quality Control

Memo

130

0.00

130

Small Fab

Small Fab

Memo

COUNTER SINK AS PER DWG

0.00

140

QC5- Inspect part completeness to step on W/O

0,00

140

OC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Work Order ID 79736

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February-01-12 8:50:39 AM

Item ID: D3150-1 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Guide
 Start Date: 01/02/2012 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 15/02/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location <u>20</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

(90) 12/15/2012

12/15/2012

MF 12-05-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

February-01-12 8:50:43 AM

Page 1

Work Order ID: 79736

79736

Parent Item: D3150-1

D3150-1

Parent Item Name: Guide

Start Date: 01/02/2012

Required Date: 15/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-09-24 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	38.5000	0.0156	0.065684			

M304S11GA

304/316 0.125 Sheet

**

IB12-5-24

Location	Loc Qty	Loc Code
MAT020	38.5	
119048	6.5	
120243	32	

~~12.380~~

12.380

9

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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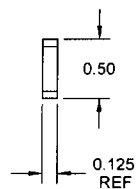
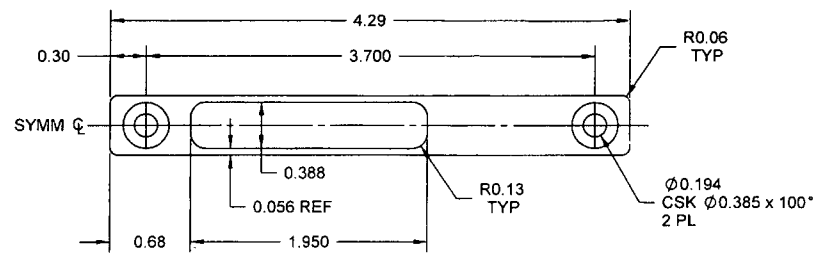
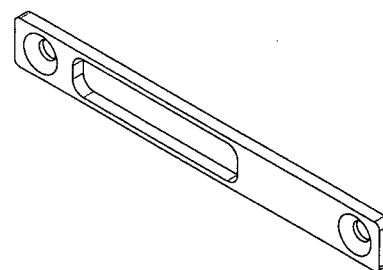
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NOTE: Date & initial all entries

SHOP COPY
FOR PART
UNCONTROLLED
SUBJECT TO A.W.

NO. 79736 M.L.J.
12/02/01



D3150-1 GUIDE

RELEASED
2010-09-23
AM



NOTES:

- 1) MATERIAL: AISI 303/304 STAINLESS STEEL SHEET, 0.125 (11 GAUGE) THICK
ANNEALED 2B FINISH
MIL-S-5059
OR ASTM A240
OR ASME SA240
PER DART SPEC M303S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.1
- 7) WEIGHT: 0.05 lbs
- 8) REPLACES PREMIER P/N B30-23000-171

C	RE-DESIGN: CHANGE MATERIAL TO 303 OR 304 WAS NORMALIZED 4130N BAR (ZN A8-1)	RF	10.09.15
B	ADD PART MARKING & NORMALIZED	RF	04.10.18
A	NEW ISSUE	RF	02.04.23
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	10.09.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3150
TITLE GUIDE
REV. C
SHEET 1 OF 1
SCALE NTS

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